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D4880-041
Job Sheet 182660



Part No: D4880-041

Job Qty: 2 ea

Part Name: 206A/B FWD Leg Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/29/18

Job Tracking No:

Due Date: 8/31/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Small Fab-4		AUG 29 2018
110	Small Fab	2 pcs	8/31/18	8/31/18	0.00	1.10	Small Fab-8		SMB DAS
120	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC5		SMB DAS 68
130	Small Fab	2 pcs	8/31/18	8/31/18	0.00	1.10	Small Fab-8		SMB DAS MLL
140	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC5		OCT 04 2018 68
180	Packaging	2 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		OCT 05 2018 9-89
190	QC21-SA	2 Ea	8/31/18	8/31/18	0.00	0.00	QC21		OCT 05 2018

Part Op 110 - ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 AND D4884-1. DRILL OUT EACH HOLES
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9971 AS PER DWG.

130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9971 A/R HYSOL BATCH: 5080785 2- LASER ENGRAVE PART# AND SERIAL # AS PER DWG

exp may 01/2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-1	Strut	2 Ea (1 ea)	90-Start up Operation	5096620
D4883-7	End Fitting	2 Ea (1 ea)	90-Start up Operation	5003367
D4884-1	End Fitting, Eye	2 Ea (1 ea)	90-Start up Operation	5046749
HL32PB5-12	Hi-Lok Pin	8 Ea (4 ea)	90-Start up Operation	5043979
HL86-5	Hi-Lok Collar	8 pcs (4 ea)	90-Start up Operation	5000790

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4880-1	2	9	0
	D4883-7	2	10	0
	D4884-1	2	6	0
	HL32PB5-12	8	83	0
	HL86-5	8	83	0



Container No: S106619



Part: D4880 - 041

Job No: 182660

Serial No/Batch: S106619

Revision:

Inspector:

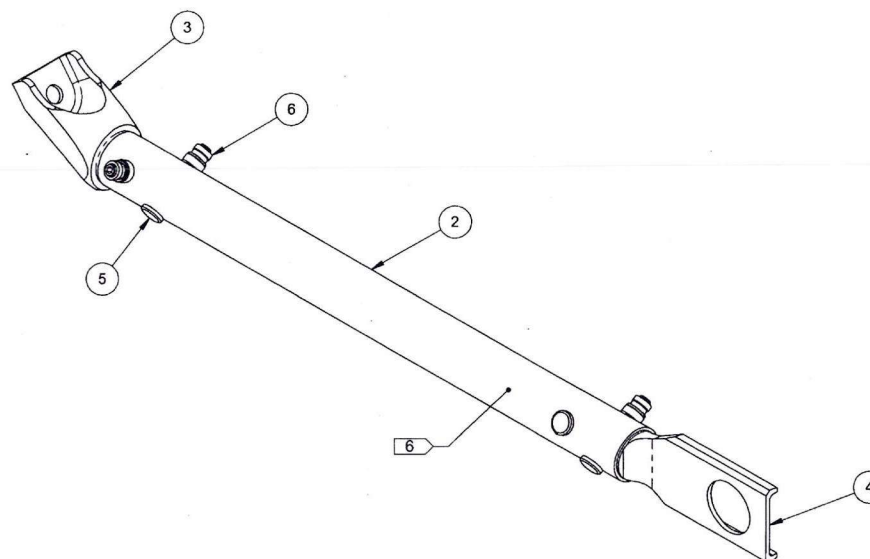
Exp Date:

Instructions: Various STC's

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Date: 08/29/18

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4880-041	FWD LEG ASSEMBLY, LH
2	1	D4880-1	STRUT
3	1	D4883-7	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4880-041 FWD LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-101-101)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 ($\phi 0.1610$) REAMER, USING DART TOOL SETUP DT9971
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9971
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

RELEASED
2014-07-03

C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 6) (ZN A8-5); ADD "FWD" (ZN B4-1, B4-2, B4-3, B4-4)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED